

Work Order ID 135611

Wednesday, August 12, 2015 4:06:02 PM

135611

Page 1

Item ID: D205-523-023 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 300 Hour Inspection
 Start Date: 8/10/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: AUG 17 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D205-523	Rev O		DAS 6 9-89						MLJ 16-01-21
100	Document Control	0.00				DAS 27 9-89			
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Type labels per PPP D205-523-023	CHG 001							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00				DAS 27 9-89			
Quality Control									

JAN 22 2016

[Signature]

DAS
6
9-89
JAN 21 2016
DAS
28
9-89

JAN 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-523-023								
	Location: FG121								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89

JAN 22 2016

MCS

JAN 22 2016

MCS

JAN 22 2016

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, August 12, 2015 4:06:01 PM

Page 1

Work Order ID: 135611

135611

Parent Item: D205-523-023

D205-523-023

Parent Item Name: 300 Hour Inspection

Start Date: 8/10/15

Required Date: 8/12/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-07-16 JLM

Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
MS21042L6		Purchased	No			110	Each	253.0000	2	2			DAS 6 9-89
MS21042L6									**	133134			DAS 28 9-89
Nut													

Location	Loc Qty	Loc Code
ST260a	35	
m132262	35	
ST273A	200	
m131624	200	
ST305	1	
m129909	1	
t260a	17	
m131317	17	

DAS
27
9-89

NAS1149D0663J

Purchased

No

110

Each

1,237.000

2

2

DAS
6
9-89

NAS1149D0663J

Washer

Location	Loc Qty	Loc Code
ST260	227	
M131618	227	
ST260a	943	
M132256	943	
ST269	67	
M126334	67	

DAS
27
9-89

D3012-1

Manufactured

No

110

Each

7.0000

2

2

DAS
6
9-89

D3012-1

Decal

Location	Loc Qty	Loc Code
ST014	7	
123244	7	

DAS
27
9-89

135646X1
140166 x 1

JAN 2 1989

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 2

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135611

Parent Item: D205-523-023

D205-523-023

Parent Item Name: 300 Hour Inspection

Start Date: 8/10/15

Required Date: 8/12/15

Start Qty: 1.00

Required Qty: 1.00

D3012-3 Manufactured No

110 Each

10.0000

2 2

DAS
6
9-89

D3012-3

Decal

**

137526

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST014

10

134674

10

D3012-5 Manufactured No

110 Each

10.0000

2 2

D3012-5

Decal

**

136157

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST014

10

134675

10

AN5-14A Purchased No

110 Each

61.0000

4 4

AN5-14A

Bolt

**

133990

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST299A

25

m132763

25

ST338

36

m131957

11

m132823

25

DAS
6
9-89
JAN 21 2016

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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D205-523-023

Parent Item Name: 300 Hour Inspection

Start Date: 8/10/15

Required Date: 8/12/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,159.000

8

8

NAS1149D0563J

Washer

**

133 363

Location

Loc Qty

Loc Code

GA	53
m125807	53
ST260a	931
m130799	63
m132035	55
m132256	213
m132677	600
ST269	156
m128257	156
ST271	19
m131026	19

DAS
6
28
9-88

DAS
27
9-89

MS21042L5

Purchased

No

110

Each

568.0000

4

4

MS21042L5

Nut

**

133 577

Location

Loc Qty

Loc Code

GA	146
m127813	146
ST260a	374
m132677	374
ST305	48
m127813	19
m131340	21
m132123	8

DAS
6
28
9-88

DAS
27
9-89

JAN 21 2016

DAS
28
9-88

DQA: _____ Date: _____



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OTHER : _____																					

DART AEROSPACE LTD.

25.4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

25.5 PARTS LIST

-013	-023	-043	Part No.	Description
X			D205-523-013	HELI-RAPPEL™ INSTALLATION
	X		D205-523-023	300 HOUR INSPECTION KIT
1		X	D205-523-043	SLIDE BAR ASSEMBLY
		1	D3011-1	RAPPEL SLIDE BAR
		2	.33116	STUD FITTING
	(2)	2	MS21042L6	NUT (OR MS21042-6)
	(2)	2	AN960JD616	WASHER
	(2)	2	D3012-1	DECAL
	(2)	2	D3012-3	DECAL
	(2)	2	D3012-5	DECAL
1			D2224	RAPPEL ANCHOR
2			D2229	DOUBLER
4	(4)		AN5-14A	BOLT
8	(8)		AN960JD516	WASHER
4	(4)		MS21042L5	NUT (OR MS21042-5)